

Date: Monday, 27/11/2006 11:47:40 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D2582	
Job Number	: 29706		Part Number	: D2582	
Estimate Number	: 10804		Drawing Number	: RTN 539	
P.O. Number	:		Project Number	:	
This Issue	: 27/11/2006	S.O. No. :	Drawing Revision	:	
Prsht Rev.	: NC		Material	:	
Frst Issue	: / /	Type	Due Date	: 04/12/2006	Qty: 1 Um: Each
Previous Run	: 00015				
Written By	:				
Checked & Approved By	:				
Comment	:				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT RTN 539	11/06/11/27 ①
2.0	D2582	Hi-Skid Step Leg Ass'y
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Hi-Skid Step Leg Ass'y ORIGINAL B/N 27756	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 ID & STK USING NEW B/N	PU 4/11/28 ① PAF E.
4.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion



11/06/11/29

Date: Wednesday, 6/28/2006 4:18:25 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HI-STEP LEG ASSEMBLY		
Job Number	: 27756					
Estimate Number	: 10355					
P.O. Number	: N/A			Part Number	: D2582	
This Issue	: 6/28/2006 S.O. No. : N/A			Drawing Number	: D2582 REV A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: A	
Previous Run	: 25395			Material	: N/A	
Written By	: <i>Sign (amount Below)</i>			Due Date	: 7/12/2006	
Checked & Approved By	: <i>KJ 06 06 29</i>			Qty:	20 Um: Each	
Comment	: Est Rev:F Removed Manufacturing 05-11-07 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	27756A	SPACER	
Comment: Sub-Component SPACER			
2.0	27756B	STEP LEG	
Comment: Sub-Component STEP LEG			
3.0	27756C	STEP SPACER	
Comment: Sub-Component STEP SPACER			
4.0	27756D	STEP SPACER	
Comment: Sub-Component STEP SPACER			
5.0	MS20470AD44	Rivet, Universal Head	
Comment: Qty.: 22.0000 Each(s)/Unit Total : 440.0000 Each(s)			
Pick: Qty Part Number Description Batch 22 MS20470AD4-4 Rivet <i>(41276) M19073 53</i> <i>255</i>			
<i>M18729 66</i> <i>242</i> <i>M100993 Cr</i>			
6.0	MS20470AD45	Rivet, Universal Head	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)			
Pick: Qty Part Number Description Batch 4 MS20470AD4-5 Rivet <i>M18461</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-31	6.1	Need D2280 picked to complete the ASS'Y. Add to estimate per msmt change.					
		Pick 2 x D2280 per ASS'Y B.27756A	SAM	06-07-31			06-07-31
06-07-31	8.0	Stack { 2x D2379 spacer B27756 I.D. } 4x D2278 B27756 Leg. in GA. AS overstack.	SAM	06-07-31			06-07-31

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-31	7.0	Open drilling and replacing rivets in the step ASS'Y, holes were oversized to over tol. R.C. drill bit wandering on rivet head, and not being centered	CP 06-08-06 per QSI 042	destroy, replace: 2x D2280 B.27756A 1x D2379 B.27756 2x D2278 B.27756 3ASS'Y Incomplete. No more D2322.	SAM 06-07-31		IP 06-08-09 per QSI 042	06-07-31

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 No
 DQA: *DS*

Date: 06/08/10

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Wednesday, 6/28/2006 4:18:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 27756

Part Number: D2582

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2582 and

SAD

06/07/30

17

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA26

S.E. 06.8.1 17

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/10 17

Job Completion



C206108/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

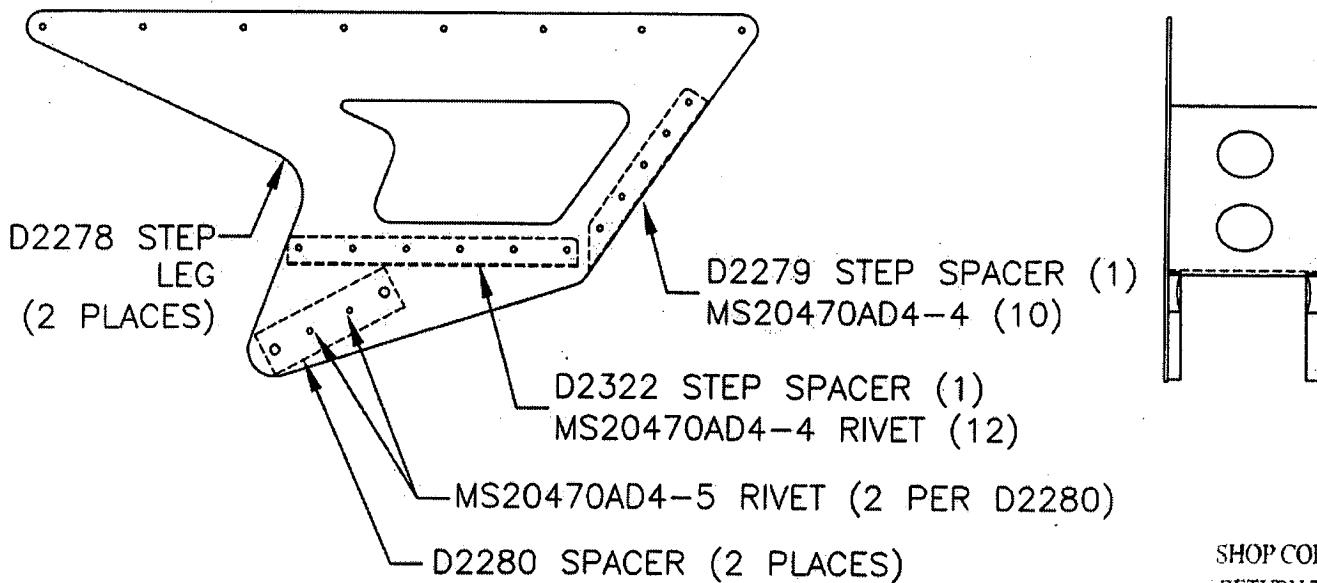
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DARTGECO CO.
2005-01-10

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D2582	REV. A SHEET 1 OF 1
DATE 01.10.05		TITLE STEP LEG ASSEMBLY	SCALE 1:5
A	01.10.05	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION
2	D2278	STEP LEG
1	D2279	STEP SPACER
2	D2280	SPACER
1	D2322	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

D2582SHOP COPY
RETURN TO

ENGINEERING

UNCONTROLLED COPY
01-10-16 SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 27756**RELEASED**

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